

Quality Specifications			
<u>Clear rPET Flakes</u>			
Pos.	Inspection criterion	Value	Inspection method
1	Material input: A PET post-consumer bottles		
2	Color: mixed transparent, light blue, colorable. Light blue	<10.000 ppm	
3	Size of flakes	1 - 10 mm	sieving 10min with 2,5mm amplitude & 20 sec interval
4	Content of flakes < 0.5mm (Dust)	0 – 0.1%	sieving 10min with 2,5mm amplitude & 20 sec interval
5	Content of flakes > 10 mm	0 - 0.5%	sieving 10min with 2,5mm amplitude & 20 sec interval
6	Maximum flakesize	10-30mm	Manuel after sieving
7	Bulk density	300-450	1l uncompressed
8	Content of opaq flakes	0 -1.5 %	optical
9	Intrinsic Viscosity IV	0.74- 0,8 dl/g	Interlaboratory
10	Impurities – sum (11-15)	0 - 150 ppm	-
11	Polyvinylchlorid	0-50 ppm	Roasting, sorting
12	Polyolefines, floatable materials	0-30 ppm	Roasting, sorting
13	PS	0 – 100 ppm	Roasting, sorting
14	Paper	0 ppm	sorting
15	Metal (incl. aluminum)	0 -5 ppm	sorting
16	Others	0 - 40 ppm	sorting
17	Flakes with glue reminders	0-0.1 %	30 min at 230°C
18	Polyamide content	0 -0.1%	30 min at 230°C
18	Residual humidity	0 -1%	20 min at 160°C
Valid from: 01.06.2013		Established by: DK	on: 13.06.2013
release: 1		Approved by: GK	on: 14.06.2013
Substitutes release of:			on:
change:		Authorised by: GK	on:14.06.2013
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